

Date: Tuesday, 10/02/2009 2:42:56 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-RAPPEL INSTALLATION
Job Number : 45680	
Estimate Number : 12261	
P.O. Number :	Part Number : D205523013
This Issue : 10/02/2009 S.O. No. :	Drawing Number : DSI9301 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 44840	Material :
Written By :	Due Date : 28/02/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09-02-10</u>	
Comment : Est. B 02.04.04 Updated Drawing and Added Inspection Level 21 SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUD 09/02/27

**Comment:** DOCUMENT CONTROL

Photocopy blue file & type labels as per PPP D205-523-013, CHG 002

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D205523043	Slide Bar Assembly
-----	------------	--------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heli-Rappel Installation

Pick:

Qty	Part Number	Description	Batch
1	D205-523-043	Rappel anchor	<u>44841</u>

4.0	D2224	Rappel Anchor
-----	-------	---------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rappel Anchor Assembly

Pick:

Qty	Part number	Description	Batch
1	D2224	Rappel anchor	<u>40891</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2229

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Doubler

Pick:

Qty Part number Description Batch

2 D2229

Doubler

33889

6.0

AN514A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Pick:

Qty Part number Description Batch

4 AN5-14A

Bolt

M109280

7.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Pick:

Qty Part number Description Batch

8 AN960JD516

Washer

M110363

8.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Pick:

Qty Part number Description Batch

4 MS21042-5

Nut

M110362

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D205-523-013

Identify and Stock

Location: _____

Rev C

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/02 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.03.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AA</i>	APPROVED <i>AA</i>	DRAWING NO. DSI 9301	REV. A SHEET 1 OF 1
DATE 05.05.11		TITLE RAPPEL ANCHOR INSTALLATION	SCALE NTS
A	05.05.11	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-523 REV. F

REF. CANADIAN STC: SH96-90 ISSUE 3

REF. FAA STC: SR00511NY, SR00512NY, SR00513NY

It has come to DART's attention that in general, AN5-13A bolts are a more suitable length for installation of the D2224 Rappel Anchor (ref) in place of the AN5-14A bolts referred to in D205-523 Rev.F.

It is acceptable to install the D2224 Rappel Anchor (ref) using longer or shorter AN5 bolts as needed to suit the thickness of the rotorcraft's ceiling panel. It is acceptable to use a light AN960JD516L washer under the head of the bolt instead of an AN960JD516 washer per D205-523 Rev. F. However, to preserve the structural integrity of the system, the washer under the MS21042L5 nut must remain an AN960JD516 washer.

For all cases, ensure the bolts properly secure the D2224 Rappel Anchor (ref) to the rotorcraft's ceiling and each bolt has at least 2 threads in safety.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45680

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 05.05.11
CERT. NO.: SH96-90
ISSUE NO.: 3

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